

GROOVING TOOL VERIFICATION PROCEDURE # 9A

August 3, 2001

Equipment Checked: **FLAT GROOVING TOOL (AASHTO T 89) (ASTM D4318)**

Purpose: This method provides instructions for checking the dimensions of the flat grooving tool.

Inspection Equipment Required:

1. Metric caliper.
2. Metric ruler.
3. Protractor
4. Straight edge.

Tolerances:

Dimensions

Letter	A ^I	B ^I	C ^I	D ^I	E ^I	F ^I ~
mm	2 ± 0.1	11 ± 0.2	40 ± 0.5	8 ± 0.1	50 ± 0.5	2 ± 0.1
Letter	G	H	J	K ^I	L ^I	N
mm	10 Minimum	13	60	10 ± 0.05	60 Deg ± 1 Deg	20

^I Essential Dimensions

~ Back at least 15 mm from tip

Note: Dimension A should be 1.9-2.0 and dimension D should be 8.0-8.1 when new to allow for adequate service life.

Procedure:

1. Check dimensions using calipers and ruler.
2. Measure angle of cutting edge using protractor.

EQUIPMENT CALIBRATION RECORD

Calibration Procedure No. 9A Grooving Tool, Flat (AASHTO T 89)

Date:	Calibrated by:
Previous Calibration Date:	Next Due:
Frequency: 12 months	
Action Recommended: Repair _____ Replace _____ None _____ Other _____	
Calibration Equipment	Serial Number
Calipers, readable to 1 mm	
Metric ruler readable to 1 mm	

Grooving Tool I.D.						
Gage End 10 ± .2 mm						
Cutting edge 2.0 ± .1 mm						
Width 13.5 ± .1 mm						
Depth of groove 10.0 ± .2 mm						